

Date: Thursday, 22/01/2009 8:04:13 AM
 User: Melanie Fauteux

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: AFT BLADE FOLD ASSY WELDMENT
Job Number	: 45047		
Estimate Number	: 13503		
P.O. Number	:	Part Number	: PB674300109
This Issue	: 22/01/2009 S.O. No. :	Drawing Number	: B6743001 P.6
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : LARGE FAB ASSY	Drawing Revision	: B1
Previous Run	: 45046	Material	:
Written By	:	Due Date	: 28/02/2009 Qty: 3 Um: Each
Checked & Approved By	: <u>MF 09-01-22</u>		
Comment	: Est Rev:A 08-06-25 new issue DD verified by:ec		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PB6743001211	Square Tubing
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Comment: Qty.: 6.0000 Each(s)/Unit Total : 18.0000 Each(s)
 Square Tubing
 batch:- 44989

MF 09-03-02

2.0	PB6743001209	Square Tubing
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)
 Square Tubing
 batch:- 43073

MF 09-03-02

3.0	PB6743001201	Square Tubing
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)
 Square Tubing
 batch:- 41572 x1, 41484 x1, 44920 x4

MF 09-03-02

4.0	PB6743001203	Square Tube
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)
 Square Tube
 batch:- 41789

MF 09-03-02

5.0	PB6743001239	Square Tube
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)
 Square Tube
 batch:- 41909 x2, 41917 x1, 44986 x3

MF 09-03-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Part Number: PB674300109

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PB6743001235

Outer Tube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Outer Tube

batch:-

B40777 x1, 41490 x2

mf 09-03-02

7.0

PB6743001229

Outer Tube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Outer Tube

batch:-

41489

mf 09-03-02

8.0

PB6743001213

Flanged Hook



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Flanged Hook

batch:-

B2400 x2, 41488 x4

mf 09-03-02

9.0

PB6743001311

Restraint



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Restraint

batch:-

B41502

mf 09-03-02

10.0

PB6743001277

Contoured Hinge Arm



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Contoured Hinge Arm

batch:-

B41499

mf 09-03-02

11.0

PB6743001243

Handle Arm Extension



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Handle Arm Extension

batch:-

40044

mf 09-03-02

12.0

D34409

Tube Detent Clip Base (Supersedes B67-43)



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Tube Detent Clip Base

batch:-

B41205 x1, B41484 x2

mf 09-03-02

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Part Number: PB674300109

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

D344013

Bracket (Supersedes B67-43001-273)



Comment: Qty.: 1.0000 Each(s)/Unit Total: 3.0000 Each(s)

Bracket

batch:-

B 41201

MF 09-03-02

14.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- assemble parts on jig DT8814 and weld as per dwg PB67-43001

** ensure no burn thru after welding in tube -235 and -229 only where bushing -265 ***

PD 09-03-06

15.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 09-03-06

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/03/06 (X2) 3X

17.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

in detail D, mask in between -311 prior to paint

mask 1.750" on the end of -243 prior to paint

mask inside of D3440-9 prior to paint

Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

11:00
OF
320
11:30

M-L 09/03/07

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SAD 09-03-07

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:


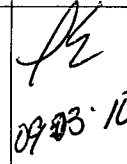

Muffin - Large Fab.

MF 09-03-09

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: PB67-43001-09 PAR #: N/A Fault Category: Feed the Leg NCR: Yes No DQA: D Date: 09/03/10
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: D Date: 09/03/10

NCR: <u>45047</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
9/3/5	14.	welder welded PB67-43001-239 in the wrong orientation. in removing the part he bent it badly saving		Scrap and Destroy PB67-43001-239 B# <u>41917</u>	 09/03/10	S 09/03/17	 09/03/17	S 9/3/5
		R.C. @ welder wasn't paying attention to what he was doing. Human error		-Dwg and w/p are clear				S 9/3/5

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Machine Or Operation:

Description :

20.0

QC21

FINAL INSPECTION/W/O RELEASE



09/03/10 *MF*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF
09-03-09

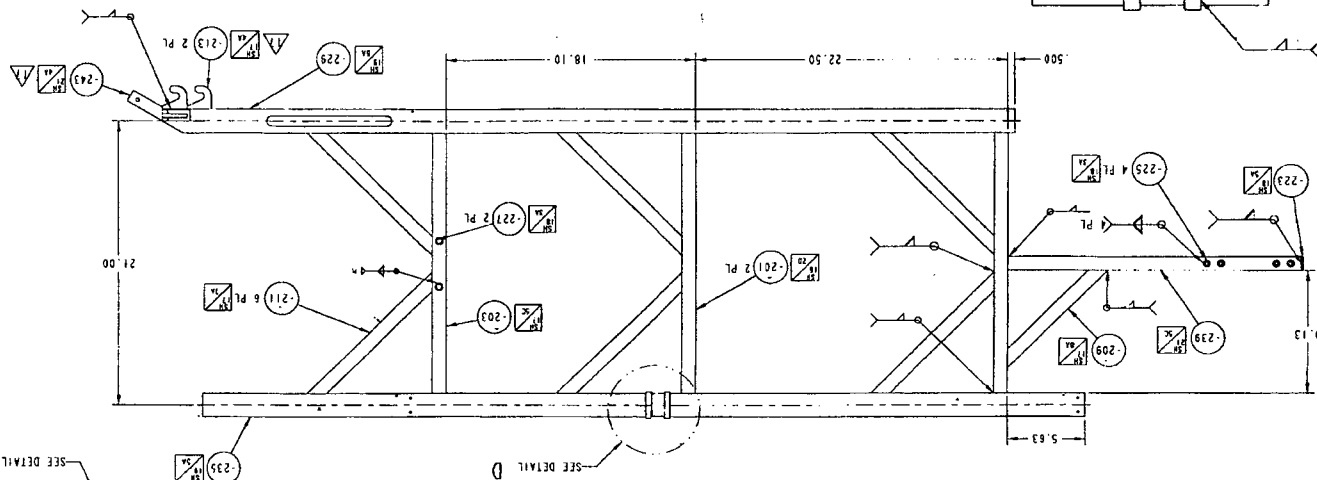
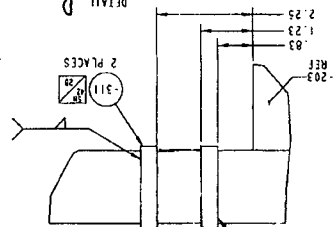
ORIGINAL

PREMIER AVIATION, INC.
2000 Aviation Parkway, Grand Prairie, Texas 75050
DLSJVB B67-43001
REV. 5 OF 45

① -09 AFT BLADE FOLD ASSEMBLY WELDMENT

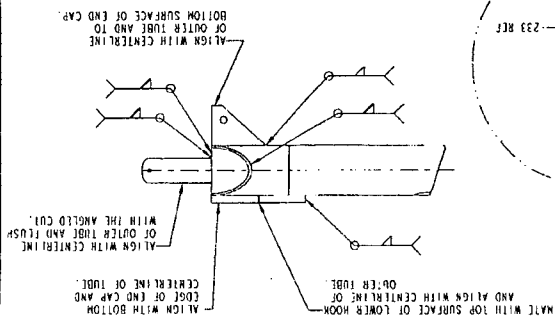
SCALE 0.250

DETAIL D
SCALE 0.750



SEE DETAIL 6

DETAIL 6
SCALE 0.500



ALIGN WITH CENTERLINE
OF OUTER TUBE AND TO
BOTTOM SURFACE OF END CAP

ALIGN WITH CENTERLINE
OF OUTER TUBE AND FLUSH
WITH THE ANGLED CUT

WELD WITH TOP SURFACE OF LOWER HOOK
AND ALIGN WITH CENTERLINE OF
OUTER TUBE

ALIGN WITH CENTERLINE
OF END CAP AND
CENTERLINE OF TUBE

ALIGN WITH CENTERLINE
OF OUTER TUBE AND FLUSH
WITH THE ANGLED CUT

ALIGN WITH CENTERLINE
OF OUTER TUBE AND TO
BOTTOM SURFACE OF END CAP

DETAIL 6
SCALE 0.500

RELEASED
BY 44-11-2

45047